

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006544**Date Inspected:** 03-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

**BAY 3****Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

FB009 – 025 – 045

FB009 – 025 – 045

FB027 – 007 – 127

FB027 – 007 – 148

**Magnetic Particle Testing**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

LD015 – 023 – 02; 03 – Green Tag # 007438

LD016 – 021 – 02; 03 – Green Tag # 007440

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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LD016 – 024 – 02; 03 – Green Tag # 007441  
LD015 – 026 – 02; 03 – Green Tag # 007444  
LD015 – 025 – 02; 03 – Green Tag # 007439  
LD017 – 014 – 02; 03 – Green Tag # 007446  
LD017 – 013 – 02; 03 – Green Tag # 007437  
LD015 – 021 – 06; 07 – Green Tag # 007443  
LD016 – 025 – 06; 07 – Green Tag # 007442  
LD015 – 022 – 02; 03 – Green Tag # 007436  
LD018 – 014 – 06; 07 – Green Tag # 007450  
LD018 – 013 – 06; 07 – Green Tag # 007451  
LD016 – 026 – 06; 07 – Green Tag # 007445  
LD016 – 023 – 06; 07 – Green Tag # 007449  
LD016 – 022 – 06; 07 – Green Tag # 007447  
LD015 – 024 – 06; 07 – Green Tag # 007448

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #023 located on Floor Beam FB019-009. Welder is identified as 044780.

ZPMC QC is identified as Li Zhi Jiang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

FCAW process welding of weld joint #054 located on Floor Beam FB003-154. Welder is identified as 044824.

ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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